



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3811
Job Sheet 200996



Part No: 646.3811

Job Qty: 28 pcs

Part Name: Radius Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/21/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	28 pcs	10/21/19		1.00	10.94	HAAS - 1	52	19/11/01
							HAAS - 2	9-89	
							HAAS - 3		
							HAAS - 4		
120	QC 2	28 pcs	10/21/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229075



Part: 646.3811

Job No: 200996

Serial No/Batch: S229075

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/01/19

QC 2 - 52	DAS	19/11/01
QC 2 - 57	52	
QC 2 - 62	9-89	
QC 2 - 63		
QC 2 - 8		
QC 2 - 66		
QC 2 - 64		
QC 2 - 65		
QC 2 - 5		
QC 2 - 71		
QC 2 - 73		
QC 2 - 69		
QC 8 - 12		
QC 8 - 14		
QC 8 - 17		
QC 8 - 20		
QC 8 - 25		
QC 8 - 3		
QC 8 - 32	J-C-1, 19-01-03	
QC 8 - 33		
QC 8 - 35		
QC 8 - 39		
QC 8 - 4		
QC 8 - 44		
QC 8 - 45		
QC 8 - 49		
QC 8 - 58		
QC 8 - 8		
QC 8 - 9		
QC 8 - 68		
QC 8 - 67		
QC 8 - 1 (A)		
QC 8 - 47		
QC 8 - 40		
QC 8 - 52		
QC 8 - 23		
QC 8 - 57		
QC 8 - 76		
QC 8 - 61		
ATG001-VC	15	2019-11-04
Packaging 2 - 1 - B4B		
Packaging 2 - 2 - B4B		
Packaging 2 - 3 - B4B		
Packaging 2 - 5 - B4B	NOV 28 2019	
Packaging 2 - 4 - B4B		
Packaging 2 - 6 - B4B		
Packaging 2 - 7 - B4B		
Packaging 2 - 8 - B4B		
Packaging 2 - 9 - B4B		
Packaging 2 - 10 - B4B		
Packaging 2 - 11 - B4B		
Packaging 2 - 12 -		
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130 QC 8 28 pcs 10/21/19 0.00 0.00

140 Outsource - 4 - Anodize 28 pcs 10/21/19

150 Packaging 2-1 - Receive - B4B 28 pcs 10/21/19 0.00 0.00

					B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	28 pcs	10/21/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	28 pcs	10/21/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Plex 9/20/19 10:08 AM Dart.Renwick.Jennifer	

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81
9-89

JAN 13 2020

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	28 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	

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		QC 21 - SA - 70			
		QC 21 - SA - 53			
Part Op 110 - (HAAS CNC Vertical Machine) 1-Machine per DWG Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - Issue P/O to ATG: <u>44992</u> AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required 150 - (Receive & Inspect for Damage & Mat'l Certs) 155 - QC6- All purchased or subcontracted products 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6B1.000X0.250	7075-T6 Bar 1.000' X 0.250"	7.4060 ft (.2645 ea)	110-HAAS 4 Axis	5223518 7.458 used	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-HAAS 4 Axis	M7075T6B1.000X0.250	7	2	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	3.000Inches ± 0.010	3.010 2.990	3.002	
2	Radius Block	0.810Inches ± 0.010	0.820 0.800	0.813	
3	Radius Block	0.190Inches ± 0.010	0.200 0.180	-188	
4	Radius Block	0.190Inches ± 0.010	RAD 0.200 0.180	0.190	

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NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QSI042)							
Description Work Order Deviation				Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
				Completed By		Lead hand / Supervisor		QC / QA Coordinator			



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER POHB044992



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044992

PO Date: 11/4/19

Due Date: 11/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

EMMAILED
2019-11-15

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197351	RBE350A93-3205-00T	RBE350A93-3205-00T Rev 3C	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed X16	-	11/22/19	16 pcs	0 pcs	16 pcs	\$6.63/pcs	\$106.08
2	200357	646.3012	646.3000 Rev NC	Lower Guide : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed X28	-	11/22/19	28 pcs	0 pcs	28 pcs	\$20.78/pcs	\$581.84
3	202282	D2348	D2348 Rev C	Wearplate (Key Way) : Various STC's Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed X60	-	11/11/19	60 pcs	0 pcs	60 pcs	\$1.83/pcs	\$109.80
4	201033	RBH9928-2	RBH9928-2 Rev K	Trim Tab Bender Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed X10	-	11/11/19	10 pcs	0 pcs	10 pcs	\$6.63/pcs	\$66.30

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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044992



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200996	646.3811	646.3800 Rev A	Radius Block : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed 1/28	-	11/22/19	28 pcs	0 pcs	28 pcs	\$7.43/pcs	\$208.04
Grand Total:												\$1,072.06

NOV 28 2019

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Number: 919031

Date: 27-Nov-19

Pack List

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
28 ea	Part: 646.3811 Radius Block Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# <u>120908</u> Job: 26395 PO: POHB044992	Rev: A	DAS 81 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 27 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		RECEIVED NOV 27 2019 DART AEROSPACE LTD.	
Made in Canada.			